Work Order ID April-11-13 2:58:00 PM	99721		*997	721*				Page 1
Item ID: 646.3810 Revision ID: Item Name: Bracket)		Accept	*N900040	100) * 9	Setup Start	11/2
Start Date: 5/24/13 Required Date: 5/24/13 Reference:	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID: Customer:				
Approvals: Process QC:	Plan: MLJ	Date: <u>13-04-1</u> 5 Date:	Tooling: SPC (Y/N):	Date:		I	Run Start Stop	"NRT"
Sequence ID/ Work Center ID	Operation Description	······································	Set Up/ Run Hours	Tool ID Tool #	Plan Code	Accept Qty	Reject Qty	Reject Insp. Number Stamp
	Revision Nbr		:					
1.4 (A) Mill Conv Conventional Milling Machine	HAAS CNC VERTICAI Memo 1-Machine DWG REV	per DWG	0.00	AJANP 13/051	/13	20	ø	
		nd break all sharp edges	<i>O</i> Z		<i>l</i> .			
*120 *120* QC	QC2- Inspect parts off n Memo	nachine FAI/FAIB	0.00	MID 13/05/1	13	20	<i></i>	

Quality Control

NCR:	Yes	/ No				WORK ORDER NON-O	CON	IFORM	MANCE / UPE	DATE			•
											QA Closed:	Date:	
Work Orde	er: _				· · · · · · · · · · · · · · · · · · ·	DISPOSITION				AGAINST DE	PARTMENT	·	. —
Part I						Rework Scrap Use-as-is Work Order Update		Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root					Descri	ption of work order update	İr	nitial	Acti	ion	Sign &		
Cause		Date	Step	Qty		or Non-conformance	Chi	ef Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved												·	
			** .			· · · · · · · · · · · · · · · · · · ·	AUL	T CATE	GORY		· · · · · ·		
Landi		Bending Centre No Cracks Crushed/O Cuffs Heat Trea nspection Ripples in Torque W	Crimped it in Strip in Bend Vaves in E	Tube Extrusio		General Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes Drawing		Instruct Mainte Mislabe Misread Offset Out of 0	ion Incomplete tions Incomplete/U enance eled d Calibration	Inclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct sissing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	1 1	Turning S	equence		I	Finish		Out of S	Sequence				

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord April-11-13 2:5		721		*99	721	. *						Page 2	
Item ID: Revision ID:	646.3810			Accept	*/	1900	040	100)* s	etup Star	t *N	S1*	
Item Name:	Bracket									Stop	*N	S2*	
Start Date:	5/24/13	Start Qty: 20.00	*20*			Cust Item II	D:						
Required Date: Reference:	: 3/24/13	Req'd Qty: 20.00	*20*			Customer:							
Approvals:	Process Pla	an:	Date:	Tooling:		Da	te:	-	R	tun Star	1/1	R1*	
	QC:		Date:	SPC (Y/N):		Da	te:			Stoj	° *N	R2*	
Sequence ID/ Work Center I	D	Operation Description		Set Up/ Run Hours	<u> </u>	Tool ID	Tool#	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	
130		QC8- Inspect parts - secon	nd check	0.00	١.	. 1				,		DAS	
130 QC Quality Control		Memo		0.00	Ø.₽	13/05/	14		20	¢_		0A5 08 	
140		Outsource process-Anodia	ze per QSI017 4.1.10.1	0.00					Ø °		11		
140 Outsource4		Memo		0.00					Co	Z 13/0	5//4	20_	
Outsource process	- Anodize		19997 ze as per Dwg 646.3800										
150		Receive & Inspect for Da	mage & Mat'l Certs	0.00						1			

0.00

Memo

150 Packaging

Packaging

NCR: Yes / No						WORK ORDER NON-	COI	NFORI	MANCE / UPI	DATE			* ·
									•		QA Closed:	Date	: :
Work Orde	er: _					DISPOSITION	_		and the late	AGAINST DE	PARTMENT,		7
Part N	_					Rework Scrap Use-as-is Work Order Update			Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	ì	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root	T				Descri	ption of work order update		Initial	Act	ion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	nief Eng	Descr	iption	Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													
1						General	AUL	T CATE	GURY				
Landi		Bending Centre No Cracks Crushed/G Cuffs Heat Trea nspection	ot Concer Crimped t n Strip in Bend	Tube		Bend BOM/Route Broken/Damaged Burrs Contamination Countersink Cut Too Short Drill Holes		Instruct Mainte Mislabe Misread Offset	ion Incomplete cions Incomplete/U enance eled	Jnclear	Ovalized Over/Under Part Incorred Part Lost/Mi Part Moved Positioned V Power Loss/	ct ssing Vrong	Pressure/Forced Temperature/Cure Weld Wrong Stock Pulled Other
	[]	Torque W	raves in E	:xtrusio	n	Drawing	1.	JOut of (Calibration				

Out of Sequence

Outside Dimensions

DQA:

Date:

Turning Sequence

Wave/Twist in Tube

Finish

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Ord		9721		*997	′21*						Page 3
Item ID: Revision ID: Item Name:	646.3810 Bracket			Accept	*N900	040	100) * s	Setup Star	I VI	S1* S2*
Start Date: Required Date: Reference:	5/24/13 : 5/24/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item II Customer:	D :					· .
Approvals:	Process Pl	lan:	Date:	Tooling: SPC (Y/N):		te:		F	Run Star Sto	μ	R1* R2*
Sequence ID/ Work Center I 155 *155* QC Quality Control	D	Operation Description QC5- Inspect part comple	teness to step on W/O	Set Up/ Run Hours 0.00	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
*160 *160* SprayPaint Spray Painting			5 4.2 ER DWG, SEE NOTE #2 4860-50 PRIMER BATCI	0.00 0.00 H: 125452	PRIME A.T.G	AT -		C&	13/0	5/14	a <u>o</u>

170

*17**0***

Quality Control

QC 4-Inspect Spray Paint

Memo

a Spray Paint

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NCR: Y	ICR: Yes / No			WORK ORDER NON-O	CON	FORM	MANCE / UPI	DATE				
	,									QA Closed:	Date:	,
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Part N	No				Rework Scrap Use-as-is Work Order Update		I Thern	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite	4	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
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Root		6.	ا م ا		ption of work order update	•	itial	Act		Sign &	Mauifiaatiau	06 1000 00400
Cause	Date	Step	Qty		or Non-conformance	Chi	ef Eng	Descr	ription	Date	Verification	QC Inspector
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Operator						1						
Material	_											
Setup												
Other Process												
Supplier								<u> </u>				
Training						1						
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Unapproved	<u> </u>		<u> </u>		F	AULT	CATE	GORY			I. <u></u>	
Landi	ng Gear				General							
	Bending				Bend		Grain			Ovalized		Pressure/Forced
	Centre N	ot Conce	ntric to C)/S	BOM/Route	П	Hardwa	ire		Over/Under	tolerance	Temperature/Cure
	Cracks				Broken/Damaged	Πı	inspecti	ion Incomplete		Part Incorred	ct	Weld
	Crushed/	Crimped			Burrs		Instruct	ions Incomplete/L	Jnclear	Part Lost/Mi	ssing	Wrong Stock Pulled
	Cuffs				Contamination		Mainte	enance		Part Moved		
	Heat Trea	at			Countersink		Mislabe	eled		Positioned V	Vrong	-
	Inspectio	n Strip in	Tube		Cut Too Short		Misread	t		Power Loss/	Surge	Other
!	Ripples ir	n Bend			Drill Holes		Offset					
	Torque V	Vaves in I	Extrusion	· [_	Drawing		Out of (Calibration				
	Turning S	Sequence	!		Finish	1 (Out of S	Sequence				

Outside Dimensions

Date:

DQA:

Turning Sequence

Wave/Twist in Tube

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde April-11-13 2:5		9721		*997	721*						Page
Item ID: Revision ID: Item Name:	646.3810 Bracket			Accept	*N9000	140°	100)*	Setup	Start Stop	*NS1* *NS2*
Start Date: Required Date: Reference:	5/24/13 5/24/13	Start Qty: 20.00 Req'd Qty: 20.00	*20* *20*		Cust Item ID Customer:) :					• • • • • • • • • • • • • • • • • •
Approvals:	Process Pl	an:	Date:	Tooling: _ SPC (Y/N):	Date				Run	Start Stop	*NR1* *NR2*
Sequence ID/ Work Center II	D	Operation Description Identify as per dwg & Sto	ck Location:	Set Up/ Run Hours 0.00	Tool ID		Plan Code	Accep Qty	t Re Qt		Reject Insp. Number Stamp
180 Packaging Packaging		Memo ***IDENTIF	Y AS PER APICAL MPI	0.00 P-120 BY STAMPING P#	# AND REV***				19	3/1/-	(27 (30)

0.00

0.00

QC21- Final Inspection - Work Order Release

Memo

190

190

Quality Control

15)1

												DQA:	Dat	e:	
NCR:	res /	No				WORK ORDER NON-	CO	NFORM	MANCE / UP	DATE					• 1
									_			QA Closed:	Dat	:e:	
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Part I						Rework Scrap Use-as-is Work Order Update		f Therm	Skid-tube Machining noforming Large Fab	Crosstube Small Fab Finishing Composite		3	Water Jet d. Eng. Coor. e/Packaging Supplier		Engineering Quality Other
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Root					Descri	ption of work order update		Initial	Ac	tion		Sign &		\sqcap	
Cause	D	ate St	ep	Qty	C	or Non-conformance	Cr	nief Eng	Desc	ription		Date	Verification	<u>. </u>	QC Inspector
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Landi	ng Gear					General		_				-	_		
	Ben	ding				Bend		Grain				Ovalized			Pressure/Forced
	Cen	tre Not Co	ncen	tric to	o/s	BOM/Route		Hardwa	re		_	Over/Under	tolerance		Temperature/Cure
	Cra	:ks				Broken/Damaged		Inspecti	on Incomplete			Part incorred	:t · [Weld
	Cru	shed/Crim	ped			Burrs		Instruct	ions Incomplete/	'Unclear		Part Lost/Mi	ssing [Wrong Stock Pulled
	Cuf	s				Contamination		Mainte	nance			Part Moved	_		
	$oldsymbol{oldsymbol{ ext{H}}}$	t Treat				Countersink	Г	Mislabe	led			Positioned V	/rong		
	Inst	ection Str	ip in ⁻	Tube		Cut Too Short		Misread	I			Power Loss/	Surge	\Box	Other

Offset

Out of Calibration

Out of Sequence

Outside Dimensions

Drill Holes Drawing

Finish

Folio

Turning Sequence
Wave/Twist in Tube

Ripples in Bend

Torque Waves in Extrusion

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Picklist Print

April-11-13 2:58:00 PM

Page 1

Work Order ID:

99721

Parent Item:

646.3810

Parent Item Name:

Bracket

Start Date: 5/24/13

Required Date: 5/24/13

Start Qty: 20.00

Required Qty: 20.00

Comments:

IPP REV:A NEW ISSUE 12-10-22 JLM VERIFIED:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T6A1.00X0.75X0.		Purchased	No			110	f	120.0000	0.1375	2.75			

7075T6 ANGLE 1.0" X .75" X .125" X .060"W

 Location
 Loc Qty
 Loc Code

 MAT036
 120

 123947
 120

6.125 MH 13/05/13

NCR: Y	CR: Yes / No					WORK ORDER NON-	COI	NFUKI	VIANCE / UP	DATE	QA Closed:	Date	:
		-				DISPOSITION				AGAINST DE			
Work Orde	:r: -						٦		alita kultu 🗀		1		7
Part N	10		·			Rework Scrap Use-as-is			Skid-tube Machining noforming	Crosstube Small Fab Finishing	1	Water Jet d. Eng. Coor. re/Packaging	Engineering Quality Other
NCR N	lo					Work Order Update]		Large Fab	Composite		Supplier	
Root					Descri	ption of work order update	П	nitial	Act	tion	Sign &		
Cause	-	Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling	_												
Operator	_												
Material	_												
Setup	i			Ï					1				
Other	_												
Process	_												
Supplier	_			ļ	1		1					:	
Training	\dashv												
Unapproved	į		<u> </u>	<u> </u>	,							<u> </u>	
				····			AUL	T CATE	GORY				
Landi						General		lc:			بالمال	Г	Pressure/Forced
	\dashv	Bending			o/s	Bend	\vdash	Grain			Ovalized	+=laranaa	 i
	\neg	Centre No	ot Concei	ntric to	^{0/s} -	BOM/Route	-	Hardwa		<u> </u>	Over/Under Part Incorred	 	Temperature/Cure Weld
	_	Cracks	Cuimamad		-	Broken/Damaged	\vdash	1	ion incomplete	Unclose	Part Lost/Mi	<u> </u>	Wrong Stock Pulled
	_	Crushed/0 Cuffs	crimped		<u> </u>	Burrs Contamination	\vdash	Mainte	ions Incomplete/	Unicieal	Part Lost/Will	DOUB _	Tantonia prock Lanea
	-	Cuiis Heat Trea	ı t		-	Countersink	-	Mislabe		 	Positioned V	Vrong	
	\dashv	Inspection		Tube	-	Cut Too Short	\vdash	Misread		 	Power Loss/		Other
	_	-		, use	-	Drill Holes	\vdash	Offset	4	<u> </u>	1. OWC: E033/.		Journe
	$oldsymbol{ o}$			xtrusio	, 	Drawing		4	Calibration				
	Ripples in Bend Torque Waves in Extrusion Turning Sequence			Finish	1	1	Sequence						

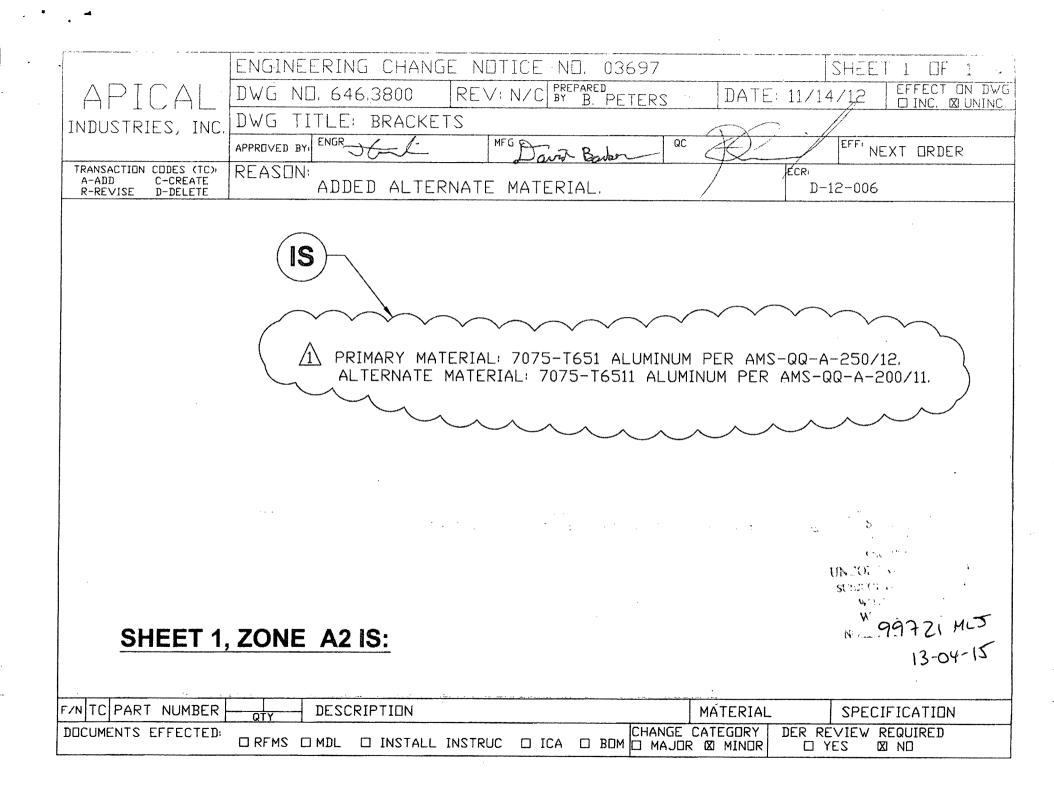
Outside Dimensions

Date: __

DQA:

Wave/Twist in Tube

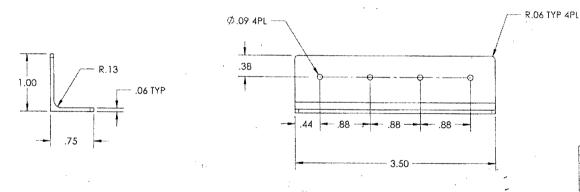
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MASSKIAN AND AND STREET AND DOMESTICS OF A 1807/12

- . 2 THRISH, MARD ANODIZETAW META-8625 TYPE II., CLASS 2, COLOR BLACK: CARDINAL 4866-50 PRETREATMENT PRIMER PRIMETAW MILIP-23377; TYPE I CLASS N
- 3. DEBURR AND BREAK ALL SHARP EDGES
- . 4. IDENTIFY IAW MPP-120

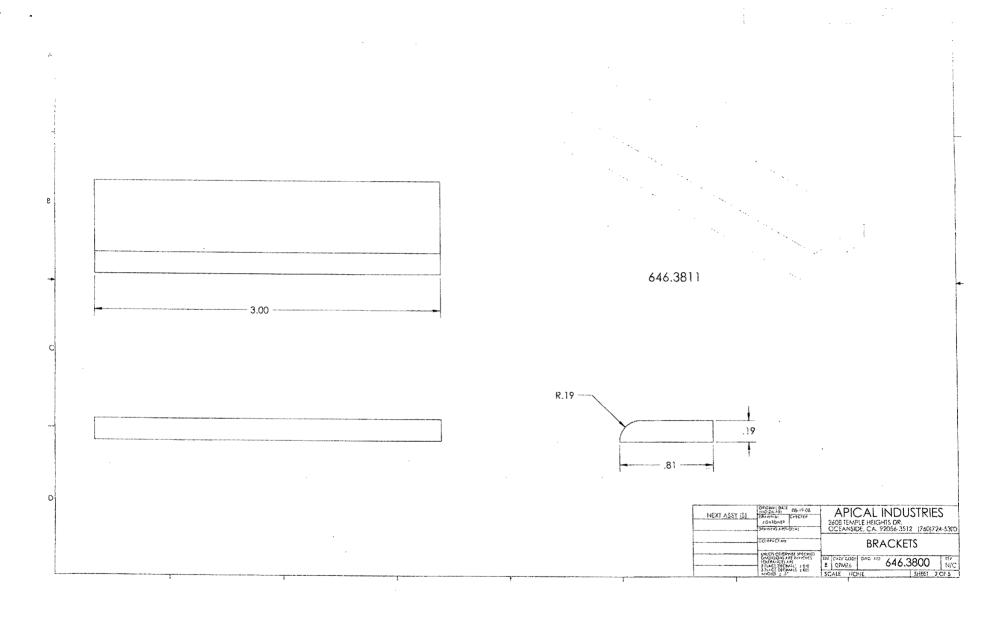
646.3810

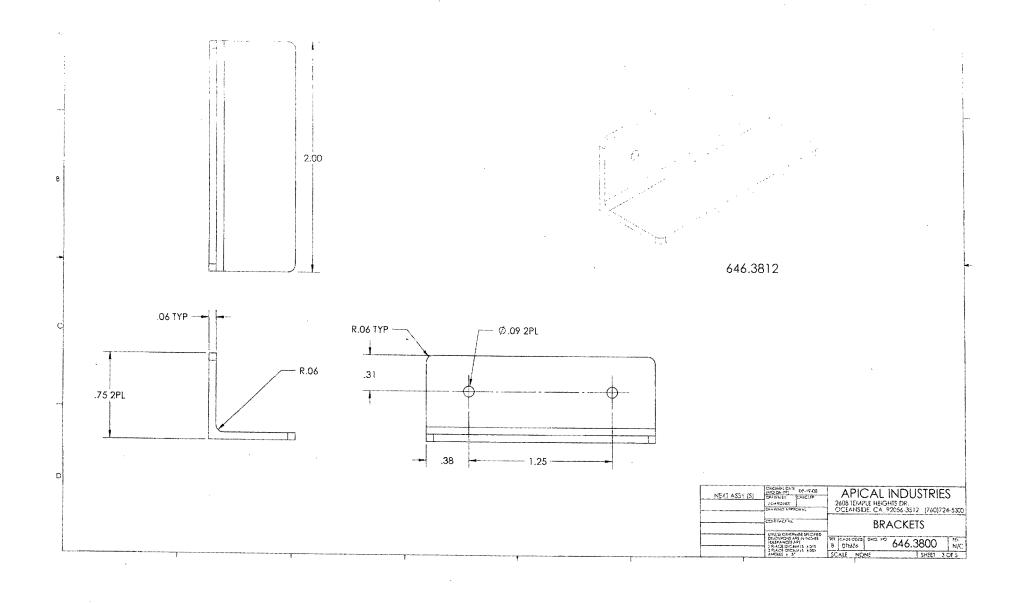


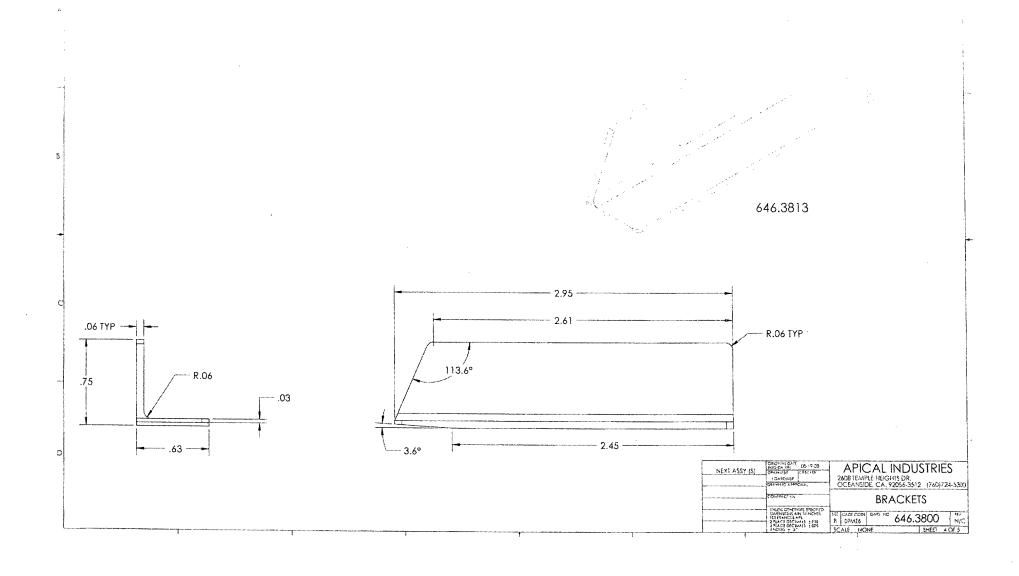
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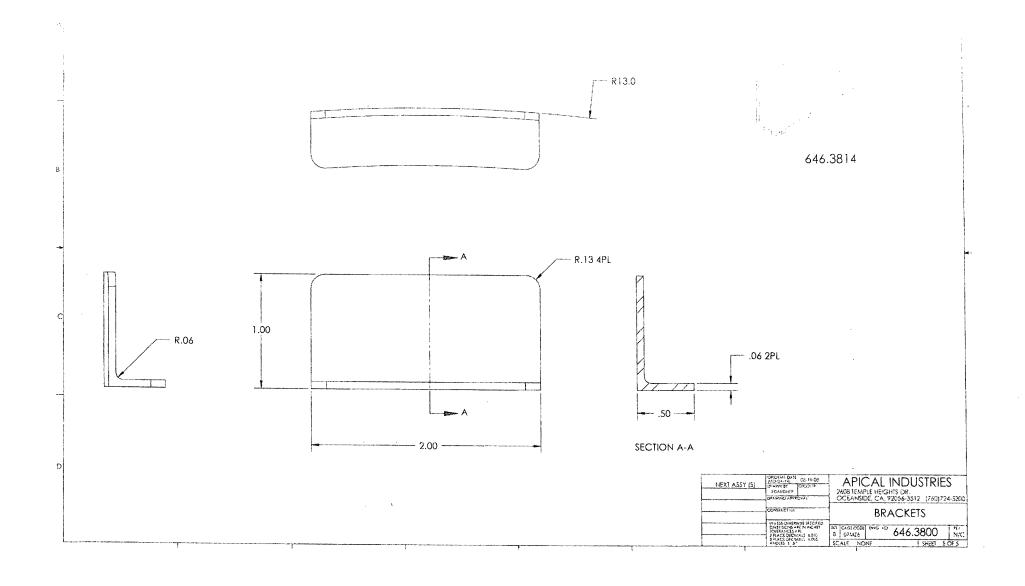
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١		646 38 4 WIPER BR	ACKET :	1 4	
		646.3813 STRUT BRA	ACKE!		Δ
		646.3812 GUSSET B	RACKET		(2)
		646.3811 RADIUS E	LOCK		2
-		645.3810 BRACKET			/2\
	QTY FIND #	PART #	DESCRIPTION	MAT'L	SPEC.
	· Q!Y	······································	PARTS LIST		
	NEXT ASSY (S)	OROGENI DATE OS-19-OS	APICAL IN	NDUSTRI	ES
	646 4000	1CYGGO ABSCOAT ON	2608 TEMPLE HEIGHT OCEANSIDE CA. 920		724-5300
		COMISSICI IRO	BRA	CKETS	
		HARESS CHIEPMON SPECIED DAMNS CHIS APE IN PACHES ICHERARDS APE 2 PRACE DECIMALS 2015 3 MACH CHICAGALS 2005 ANGELS CHICAGALS 2005 ANGELS CHICAGALS 2005	SE SCALE NONE	546.3800	N/C







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DART AEROSPACE LTD	Work Order:	79721
Description: Bracket	Part Number:	646,3810
Inspection Dwg: 646, 3800 Rev:		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
3,50	+ 0,010	3,494	/		MJP-04	Veru
00,090	- 0,001	0,090			111	111
0,38	+ 0,010	0,378	/		111	,,1
0,44	+ 0,010	0,437	V		111	111
0,88	+ 0,010	0,881	V		111	111
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0,88	+ 0,010	0,882	V'		111	, , ,
0,88 R0,06	+ 0,010	0,062	/			Radius Gage
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Measured by:	Mellan	Audited by:	b.a	70	Preliminary Approval:	
Date:	13/05/13	Date:	13/05/14	8-89	Date:	

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	



A.T.G. Industries Inc. 731, rue Industrielle Rd. PLATING DEPARTMENT Rockland, On K4K 1T2 Canada

Ph: (613) 446-4544 Fax: (613) 446-4556

Pack List

Number: 62398

Date: 24-May-13

То

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 Canada Ship To

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

Terms						
terms		Ship Via				
Quantity	Description					
1	Part: ASST		Rev:			
lot						
(-	20 PCS 646.3812 10 PCS 646.3717 20 PCS 646.3718 20 PCS 646.3719 10 PCS 646.3713 12 PCS 646.3714 25 PCS 646.3813 32 PCS 646.3810 HARD ANODIZE BLACK MIL-A-8625 TYPE III CLASS 2					
I	PRIME MIL-P-23377J TYPE I CLASS	3 N				
,	6 PCS D4703-042 16 PCS D4726-1 BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 Job: 20130308	PO: 19887	Line:			
	Certificate of Confo	ormance				
	A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001: 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: 24/5/3 CERTIFIED SIGNATURE:					
	RECEIVER SIGNATURE :					